

Date: Friday, 03/04/2009 10:19:36 AM
 User: Julie Dawson

Process Sheet

| | | | |
|-----------------------|---------------------------------------|------------------|------------------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : PANEL-W/ ROTOR BRAKE |
| Job Number | : 46917 | | |
| Estimate Number | : 13584 | | |
| P.O. Number | : | Part Number | : D38213 |
| This Issue | : 03/04/2009 S.O. No. : | Drawing Number | : D38213 |
| Prsht Rev. | : NC | Project Number | : IN0002 |
| First Issue | : / / Type : THERMOFORMING | Drawing Revision | : A |
| Previous Run | : 43178 | Material | : MKYD6185S080P362015 |
| Written By | : | Due Date | : 10/04/2009 Qty: 2 Um: EACH |
| Checked & Approved By | : <u>JUDAWSON 03</u> | | |
| Comment | : Est. A New Issue 08/09/17 DL | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|---------------------|------------------|
| 1.0 | MKYD6185S080P362015 | 6185 KYDEX .080" |
|-----|---------------------|------------------|



Comment: Qty.: 13.2489 sf(s)/Unit Total : 26.4978 sf(s)
 6185 Kydex .080"

M109703

| | | |
|-----|----------------|------------------------------|
| 2.0 | HAND FINISH TH | HAND FINISHING THERMOFORMING |
|-----|----------------|------------------------------|



Comment: HAND FINISHING THERMOFORMING

1) Machine set up

BB 09/04/07

| | | |
|-----|----------------|------------------------------|
| 3.0 | HAND FINISH TH | HAND FINISHING THERMOFORMING |
|-----|----------------|------------------------------|



Comment: HAND FINISHING THERMOFORMING

1) Cut sheet to required blank size

BB 09/04/07 (x2)

| | | |
|-----|---------------|-----------------------|
| 4.0 | THERMOFORMING | THERMOFORMING MACHINE |
|-----|---------------|-----------------------|



Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D3821-3 and folio FTA 024 using tool DT 9054

Dwg. Rev. A

Folio Rev. _____

BB 09/04/07

| | | |
|-----|-----|--|
| 5.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

BB 09/04/07 (x2)

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Date: Friday, 03/04/2009 10:19:36 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PANEL-W/ ROTOR BRAKE

Job Number: 46917

Part Number: D38213

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



09/04/14 (2)



Comment: SECOND CHECK

7.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

BB 09/04/08 (X2)

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



09/04/14 (2)



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

9.0

QC5

INSPECT WORK TO CURRENT STEP



09/04/14 (2)



Comment: INSPECT WORK TO CURRENT STEP

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

09/04/15 (2)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



09/04/16 (2)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 09-04-16

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | | |
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NOTE: Date & initial all entries

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|-----------------------------------|--|--------------|---------|
| DART AEROSPACE LTD | | Work Order: | 46917 |
| Description: PANEL W/ ROTOR BRAKE | | Part Number: | D3821-3 |
| Inspection Dwg: D3821 Rev: A | | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

| Description | Accept | Reject | Method of Inspection | Comments |
|---|--------|--------|----------------------|----------|
| Inside Radii less than " | ✓ | | | |
| Shape Definition | ✓ | | | |
| Texture Retention | ✓ | | | |
| Material imperfections such as bumps, cracks, voids, scratching | ✓ | | | |
| | | | | |
| | | | | |
| | | | | |
| | | | | |

Measured by: BB

Date: 09/24/08

TRIMMING SECTION

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|-----------------|------------------|--------|--------|----------------------|----------|
| .020 | Min. .01 | .042 | ✓ | | | |
| .050 | Min | .058 | ✓ | | | |
| 30.9 | 30.9 | 30.95 | ✓ | | | |
| .75 | | .740 | ✓ | | | |
| 1.00 | | 1.1 | ✓ | | | |
| 29.6 | | 29.75 | ✓ | | | |
| .25 | Min Typ | .297 | ✓ | | | |
| | | | | | | |
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Measured by: BB

Date: 09/24/08

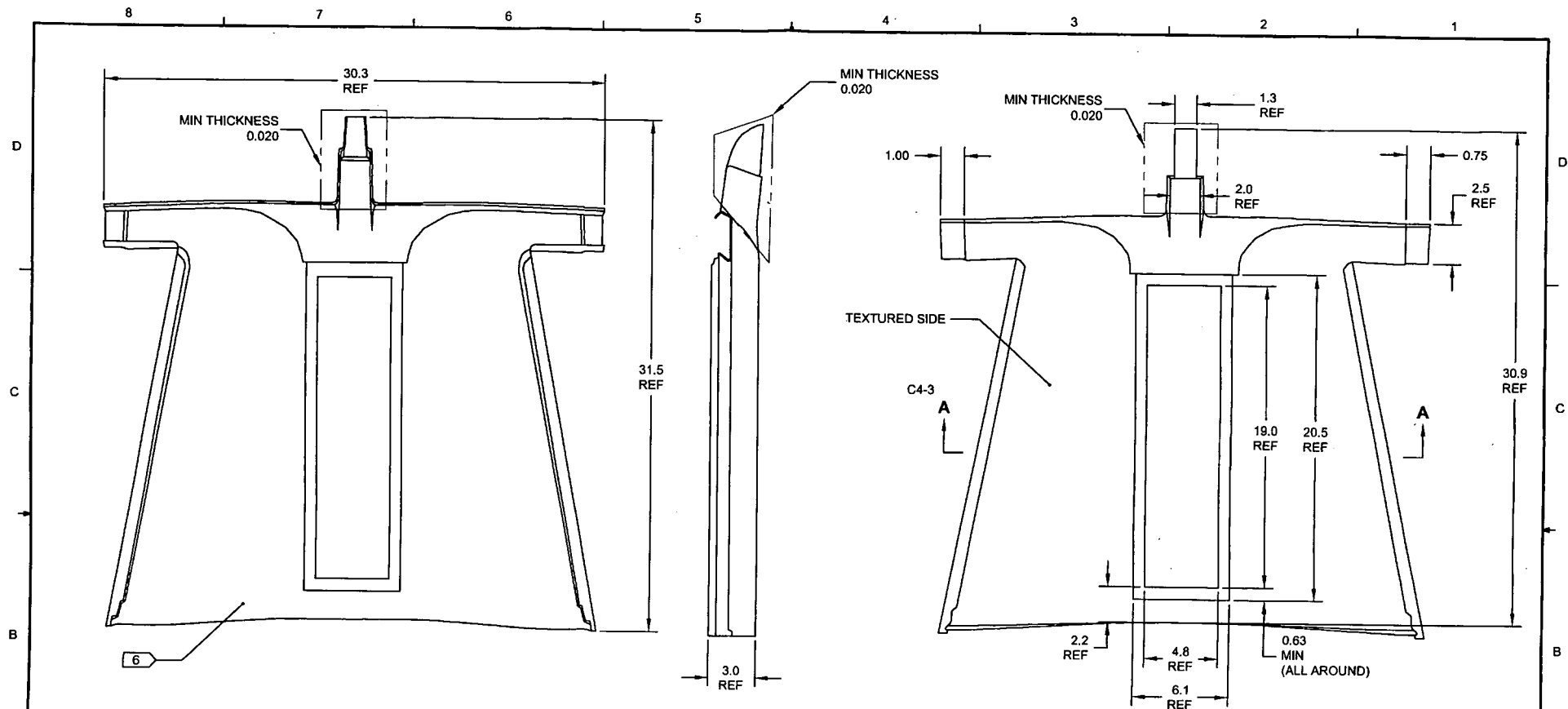
Audited by:

Date: 09-24-08

Prototype Approval:

Date:

| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A | | New Issue | KJ/DL | |



D3821-1 PANEL, WITHOUT ROTOR BRAKE
(BELL 206 A/B)

NOTES:

- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015
(REF DART SPEC MKYD6185S.080-P3-62015)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3821-1" USING VIBRATING STYLUS
- 7) WEIGHT: 2.2 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9053 PER DART QSI 022. TRIM PER MOLD.
- 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED

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ENGINEERING
SHOP COPY

VIEW C B4-3

RELEASED
09/01/72/VB

| REV. | NEW ISSUE | PH | 08.09.29 |
|------------|-------------|----|----------|
| DESIGN | DESCRIPTION | BY | DATE |
| DRAWN | | | |
| CHECKED | | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 08.09.29 | | |

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
DRAWING NO. D3821
REV. A
SHEET 1 OF 4
TITLE PANEL (BELL 206 A/B)
SCALE NTS

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Dart Aerospace Ltd

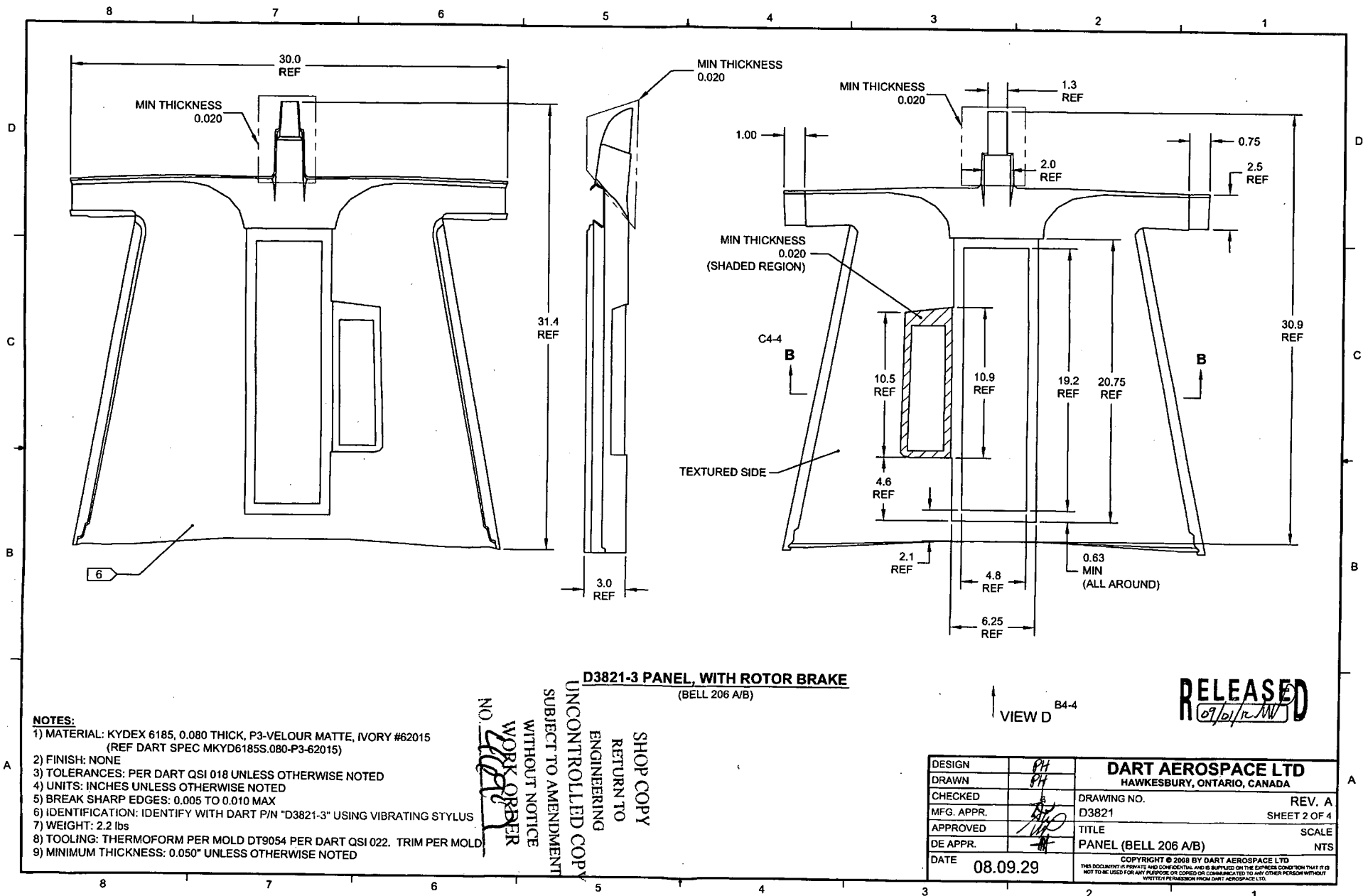
| W/O: | | WORK ORDER CHANGES | | | | | | |
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NOTE: Date & initial all entries



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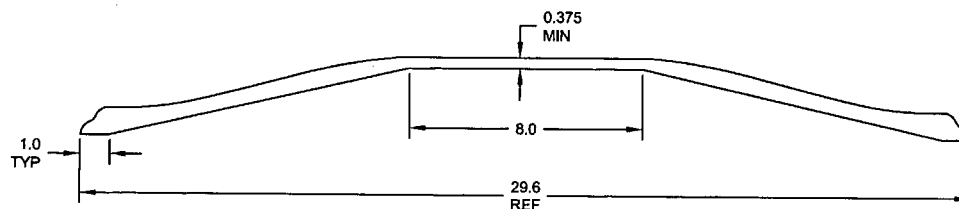
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NOTE: Date & initial all entries

SECTION A-A C4-1



VIEW C A2-1



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07/01/12 MJD

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|------------|----------|---|--------------|
| DESIGN | PH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | PH | | |
| CHECKED | PH | DRAWING NO. | REV. A |
| MFG. APPR. | PH | D3821 | SHEET 3 OF 4 |
| APPROVED | PH | TITLE | SCALE |
| DE APPR. | PH | PANEL (BELL 206 A/B) | NTS |
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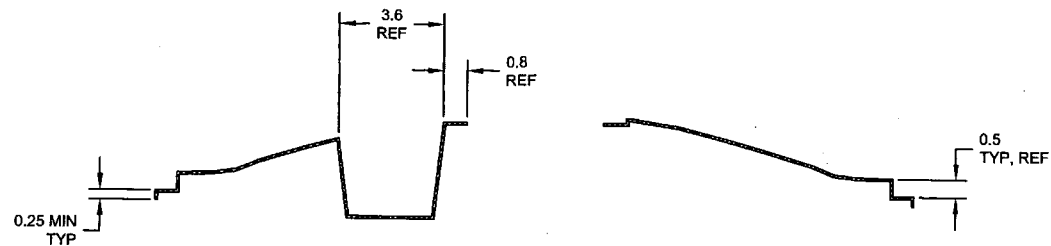
| W/O: | | WORK ORDER CHANGES | | | | | | |
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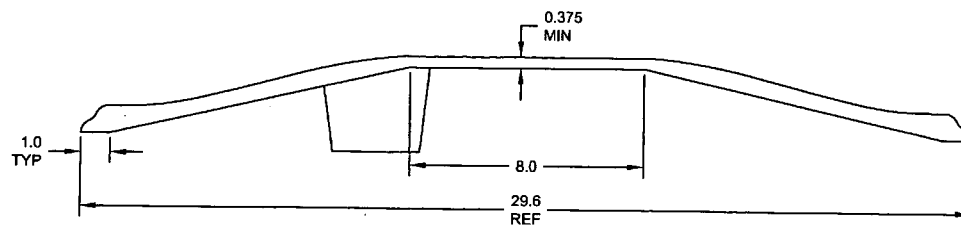
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NOTE: Date & initial all entries






SECTION B-B C4-2



VIEW D C4-2

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NO. 10017

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08/01/02

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| DRAWN | PH | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. |  | D3821 | SHEET 4 OF 4 |
| APPROVED |  | TITLE | SCALE |
| DE APPR. |  | PANEL (BELL 206 A/B) | NTS |
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